

Date: Wednesday, 13/08/2008 8:34:04 AM  
User: Linda Lacelle

# Process Sheet

<b>Customer</b>	: CC-DAR01 Dart Aerospace Ltd.	<b>Drawing Name</b>	: INITIAL PROTOTYPE TEMPLATE
<b>Job Number</b>	: 00233A		
<b>Estimate Number</b>	: 10068		
<b>P.O. Number</b>	:	<b>Part Number</b>	: INITIAL PROTOTYPE
<b>This Issue</b>	: 13/08/2008 <b>S.O. No.</b> :	<b>Drawing Number</b>	:
<b>Prsht Rev.</b>	: NC	<b>Project Number</b>	: N/A
<b>First Issue</b>	: 18/12/2007 <b>Type</b> : R&D CROSSTUBES	<b>Drawing Revision</b>	:
<b>Previous Run</b>	: 00232A	<b>Material</b>	:
<b>Written By</b>	: _____	<b>Due Date</b>	: 05/11/2007 <b>Qty:</b> 1 <b>Um:</b> Each
<b>Checked &amp; Approved By</b>	: _____		
<b>Comment</b>	: Project #: _____ Description: _____		

### Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1	1000	1000
2	1000	1000
3	1000	1000
4	1000	1000
5	1000	1000
6	1000	1000
7	1000	1000
8	1000	1000
9	1000	1000
10	1000	1000
11	1000	1000
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93	1000	1000
94	1000	1000
95	1000	1000
96	1000	1000
97	1000	1000
98	1000	1000
99	1000	1000
100	1000	1000

1.0	MFG ENGINEERING	MFG ENGINEERING
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**Comment:** MFG ENGINEERING

Manufacture Prototype as per Dwg's Supplied By Engineering

Comments:

1000

2.0	PG	PURCHASING
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**Comment:** PURCHASING

Attached certificate of conformity for raw material and subcomponents use for this w/o

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Part Number: INITIAL PROTOTYPE

Job Number:



Seq. #:	Machine Or Operation:	Description :
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3.0	D6017115	Crosstube Material
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Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)  
Crosstube Material

4.0	MORI SEIKI	MORI SEIKI CNC LATHE LARGE
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Comment: MORI SEIKI CNC LATHE LARGE  
TURN PER DRWG D350-748-141

5.0	BENDING CROSS	BENDING MACHINE - CROSSTUBES
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Comment: BENDING MACHINE - CROSSTUBES  
BEND DEVELOPMENT OF D350-748-141

6.0	D6001105	Crosstube, Material
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)  
Crosstube, Material  
TURN PER DRWG D206-667-141

7.0	D6003102	Crosstube, 206
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)  
Crosstube, 206  
TURN PER DRWG D206-667-241

8.0	D6001105	Crosstube, Material
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)  
Crosstube, Material  
TURN PER DRWG D058-676-141

9.0	D6007106	Crosstube, OH58
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)  
Crosstube, OH58  
TURN PER DRWG D058-676-241

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Job Number: 00233A

Part Number: INITIAL PROTOTYPE

Job Number:



Seq. #:	Machine Or Operation:	Description :
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10.0	BENDING CROSS	BENDING MACHINE - CROSSTUBES
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Comment: BENDING MACHINE - CROSSTUBES  
ABOVE 4 EXTRUSIONS FOR BENDING  
DEVELOPMENT OF :  
D206-667-101  
D206-667-201  
D058-676-101  
D058-676-201

11.0	D25001190	Ext'n -1' Beam Tube 4"
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)  
Ext'n -1' Beam Tube 4"

12.0	D26001160	Extrusion Round 3" 206
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)  
Extrusion Round 3" 206

13.0	D26001190	Extrusion Round 3" 206
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)  
Extrusion Round 3" 206

14.0	D26001190	Extrusion Round 3" 206
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)  
Pick:  
Extrusion Round 3" 206  
Qty Part Number Description Batch  
1 D2600-1-190 3" OD Tube

15.0	D6017115	Crosstube Material
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)  
Crosstube Material

ISA. D206-667-203 TRN B 37986

W 08/08/19

(PTC)

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Drawing Name: INITIAL PROTOTYPE TEMPLATE

Job Number: 00233A

Part Number: INITIAL PROTOTYPE

Job Number:



Seq. #:

Machine Or Operation:

Description :

16.0

D6009129

Crosstube Material



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)  
Crosstube Material

17.0

D6003102

Crosstube, 206



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)  
Crosstube

18.0

D6004115

Crosstube Material



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)  
Crosstube material

19.0

D350748141TRN

Crosstube Turning Detail



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)  
Crosstube Assembly, High Fwd

20.0

D206667201

Crosstube Aft



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)  
Crosstube Aft

21.0

D6018125

Crosstube Material



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)  
Crosstube Material

22.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING  
Identify "FOR ENGINEERING USE ONLY" and distribute to engineering.

23.0

ENGINEERING 1

ENGINEERING RESOURCE #1



Comment: ENGINEERING RESOURCE #1  
Approval of project manager \_\_\_\_\_

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Part Number: INITIAL PROTOTYPE

Job Number:



Seq. #:

Machine Or Operation:

Description :

24.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



W 8/8/17

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D206-667-203TRN PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: AS Date: 08-08-24  
 QA: N/C Closed: DD Date: 08/08/24

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
080813	15.A	Tube was over bent during bend development, and tube is very un-even.	<u>[Signature]</u> 08/08/19	Scrap and destroy	<u>[Signature]</u> 08-08-19	<u>[Signature]</u> 08/08/19	<u>[Signature]</u> 08/08/19	<u>[Signature]</u> 08/08/13

NOTE: Date & initial all entries